Work Order ID 119401

Thursday, May 15, 2014 3:56:53 PM

119401

D4793-1
D 4 7 9 3 - 1
B 1 1 9 4 0 1

Item ID: D4793-1
Revision ID:
Item Name: Handle Plate
Start Date: 5/15/14 **Start Qty:** 4.00
Required Date: 5/15/14 **Req'd Qty:** 4.00
Reference:

Accept *N900040100*

Setup **Start** *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Approvals: **Process Plan:** MLS **Date:** 14-05-21 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run **Start** *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D4793 / Revision Nbr: A									
100		0.00							DAS 23 9-89 14-07-9
100									
Waterjet	**Memo**	0.00				10	0		
FLOW CNC Waterjet 304 .125"	Cut as per dwg D4793 Prog Rev: A Dwg Rev: A Deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 23 9-89 14-07-9
110									
QC Quality Control	**Memo**	0.00				10	0		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

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Revision ID:
Item Name: Handle Plate
Start Date: 5/15/14 **Start Qty:** 4.00 *4*
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Setup Start *NS1*
Stop *NS2*
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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

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120	QC8- Inspect parts - second check	0.00				10			
120									
QC	**Memo**	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: ST/21	0.00							
140									
Packaging	**Memo**	0.00				10X		14-7-9	DAS .26 9-89
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	**Memo**	0.00				MLJ 14-0709			
Quality Control									

SMP 14-7-9

MF 14-07-09

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

Thursday, May 15, 2014 3:56:57 PM

Work Order ID: 119401

119401

Parent Item: D4793-1

D4793-1

Parent Item Name: Handle Plate

Start Date: 5/15/14 **Required Date:** 5/15/14

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP REV:A 13.06.17 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	168.2000	0.0187	(1)			DAS 23 9-89
M304S11GA									**				
304/316 0.125 Sheet													

14-07-9

Location	Loc Qty	Loc Code
MAT020	168.2	
122521	30	
M128254	138.2	

M28254.

DQA: _____ Date: _____

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Part No. _____

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Supplier	☐									
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☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
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☐ Weld
☐ Wrong Stock Pulled
☐ Other

DART AEROSPACE LTD	Work Order:	119401
Description: Handle Plate	Part Number:	D4793-1
Inspection Dwg: D4793 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75"	+-0.030"	0.751"	-		V	JKM01
3.60"	"	3.603"	-		V	
0.13"	"	0.116"	-		V	

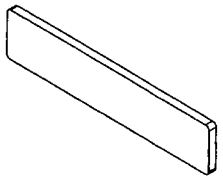
Measured by:	DAS 23 ~~9-89~~	Audited by:	DAS 27	Preliminary Approval:	
Date:	14.07.9	Date:	M 7/9	Date:	

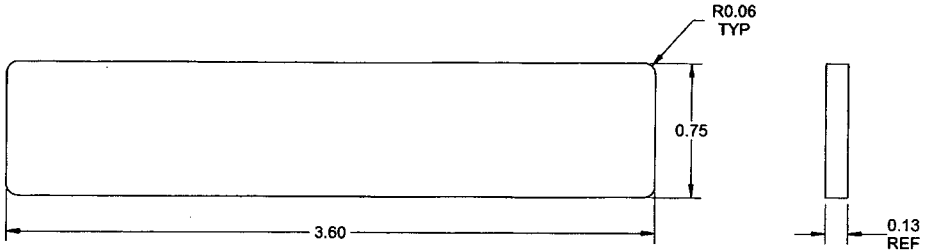
Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 169101 MCS

1405-21





D4793-1 HANDLE PLATE

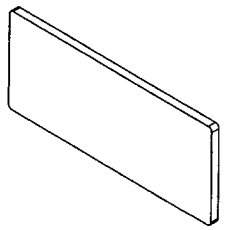
RELEASED
2013 -06- 12

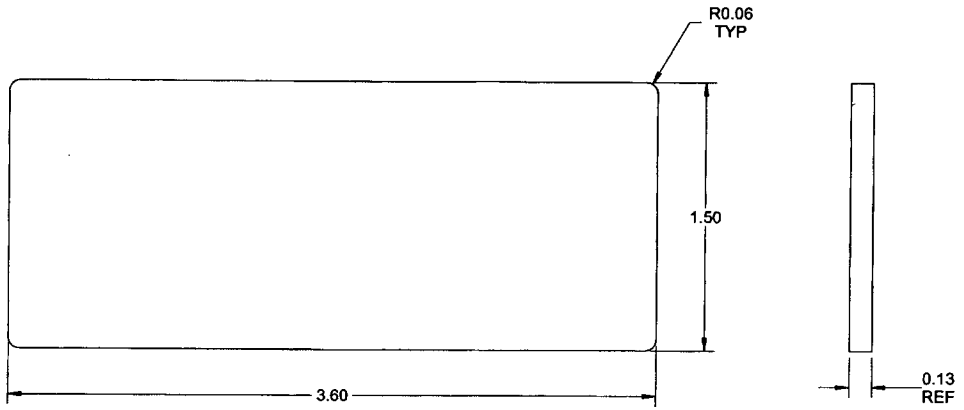
NOTES:
1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
2) FINISH : NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.10 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	RF	13.05.24

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO. D4793	REV. A
MFG. APPR.			SHEET 1 OF 2
APPROVED		TITLE HANDLE PLATE	SCALE NTS
DE APPR.			
DATE	13.05.24		

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D4793-3 WIDE HANDLE PLATE

RELEASED
2013 -06- 12

NOTES:
1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
2) FINISH : NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.19 lbs

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D4793 REV. A SHEET 2 OF 2
CHECKED	BC	TITLE HANDLE PLATE SCALE NTS
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	13.05.24	

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